

Date: Wednesday, 4/4/2007 9:14:36 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BASKET (A119) STRUT
 Job Number : 31628
 Estimate Number : 12436
 P.O. Number : N/A Part Number : D35171
 This Issue : 4/4/2007 S.O. No. : N/A Drawing Number : D3517 PRELIMINARY Rev. A
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : R & D SM/MED FAB Drawing Revision : A PRELIMINARY A
 Previous Run : 29574 Material : N/A
 Due Date : 4/30/2007 Qty: 10 Um: Each
 Written By :
 Checked & Approved By :
 Comment : EST rev. A 05.06.06 preliminary EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0750X04000 6061-T6 Bar .75" x 4.0"



Comment: Qty.: 0.6999 f(s)/Unit Total : 6.9993 f(s) 7.6992

6061-T6 Bar .75" x 4.0"

Batch: M101283

ml 07 04 18

(11)

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3517

Dwg Rev: A

Prog Rev: A

ml 07 04 19 (11)

2-Open holes to finish size as per Dwg D3517 ml 07 04 19

(11)

3-Deburr if necessary

ml 07 04 19 (11)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

2024.24 (11)

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

ml 07/04/24

(11X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: Date: 01/04/27
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng				

NOTE: Date & initial all entries

Date: Wednesday, 4/4/2007 9:14:36 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET (A119) STRUT

Job Number: 31628

Part Number: D35171

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M103706



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

HL

07-04-24

(11)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(11X)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-L

07/04/25

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: St 2/2

SP

7/4/26

50

(11)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



(16)

Comment: FINAL INSPECTION/W/O RELEASE

07/04/27

Job Completion



W 07-04-27

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

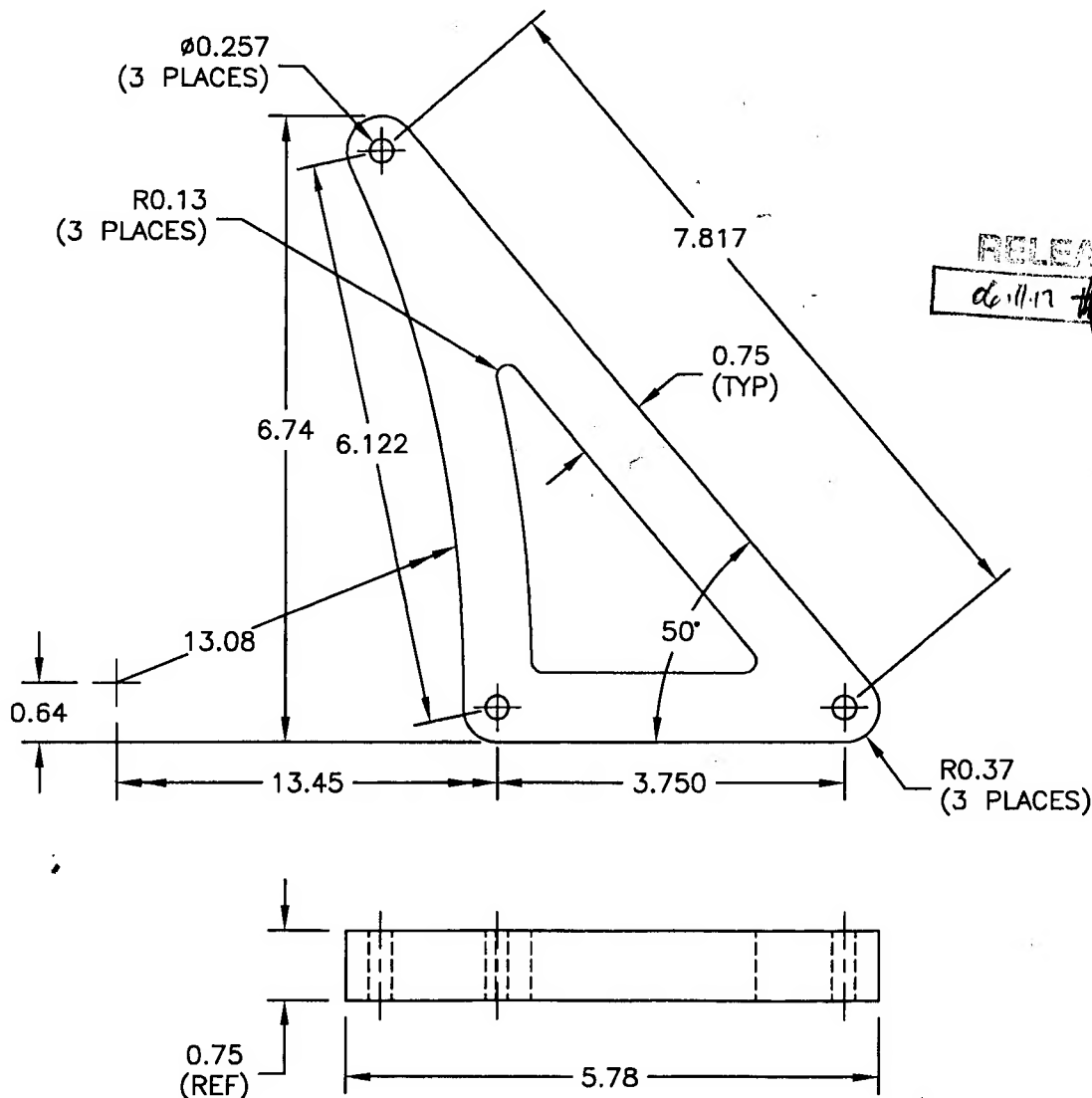
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng				

NOTE: Date & initial all entries



DESIGN B	DRAWN BY B	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3517	REV. A SHEET 1 OF 1
DATE 06.06.07		TITLE BASKET (A119) STRUT	SCALE 1:2
A	06.06.07	NEW ISSUE	



D3517-1 STRUT

- 1) MATERIAL: M6061-T6 (OR 6061-T651/T6510/T6511/T6512/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF DART MATERIAL SPEC M6061T6B0.750X00.750)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) IDENTIFY WITH DART P/N D3517-1 USING FINE POINT PERMANENT INK MARKER
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES 0.005 TO 0.010 MAX

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. _____

Copyright © 2006 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART AEROSPACE LTD		Work Order: 31628
Description: Basket (A119) strut		Part Number: D3517-1
Inspection Dwg: D3517 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 6.74	+/-0.030	6.742	✓		VERN	
B 6.122	+/-0.010	6.122	✓		VERN	
C 7.817	+/-0.010	7.824	✓		VERN	
D 3.750	+/-0.010	3.754	✓		VERN	
E 0.75	+/-0.030	0.75	✓		VERN	
F Ø 0.257	+0.006-0.001	0.257	✓		VERN	
G						
H						
I						
J						
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: <i>MM</i>	Audited by: <i>[Signature]</i>	Prototype Approval:	N/A
Date: 07 04 19	Date: 07 04 24	Date:	N/A
Rev	Date	Change	Revised by
		New Issue	KJ/RF
			Approved

[Signature]